

Work Order ID 67584

Monday, March 28, 2011 11:40:55 AM



Page 1

Item ID:	D3278-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Support Assembly				Stop	
Start Date:	3/28/2011	Start Qty:	40.00		Cust Item ID:	
Required Date:	3/31/2011	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-03-28	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								
100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Rivet spacers with support as per Dwg D3278.								
110		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble support as per Dwg D3278. ***DO NOT TIGHTEN BOLTS*** Identify as D3278-041								

EPH/03/31 (36)

count (36)

8 w/bs/3 t

EPH/04/12 (36)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67584

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Item ID: D3278-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Assembly

Start Date: 3/28/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

m 11 04 13 (36)

140

Identify as per dwg & Stock Location: ST471

0.00



Packaging

Memo

0.00

Packaging

E 50/04/14 (36)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/14 JF

MF
11-04-14

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Picklist Print

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Work Order ID: 67584

Parent Item: D3278-041

Parent Item Name: Support Assembly





Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐A☐04.04.19☐New issue☐KJ/JLM
IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1  Support		Manufactured	No			100	Each	40.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				GA				40					
					66948			40					
D3278-2  Support		Manufactured	No			100	Each	36.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				GA				36					
					65075			5					
					66943			31					
D3278-3  Spacer		Manufactured	No			100	Each	40.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				GA				40					
					66547			40					
MS21042L4  Nut		Purchased	No			100	Each	3,493.000	2	80			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST300				3493					
					116188			1493					
					116823			2000					

EPH/03/30

36
EPH/03/30

5
31
EPH/03/30

36
EPH/04/12

72

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, March 28, 2011 11:41:01 AM

Page 2

Work Order ID: 67584

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 40.00

Required Qty: 40.00

AN4-13A

Purchased

No

120

Each

338.0000

2

80



Bolt

Location

Loc Qty

Loc Code

ST357

338

116786

38

117094

300

120

Each

0.0000

4

160

AN960JD416

NAS1149D0463J

Purchased

No



Washer

D2230-1

Manufactured

No

120

Each

20.0000

2

80



Lug

Location

Loc Qty

Loc Code

ST476

20

65270

20

120

Each

4,093.000

4

160

MS20426AD3-6

Purchased

No



Rivet

Location

Loc Qty

Loc Code

ST316

4093

105055

523

116289

3570

EP 5/11/04/12
M117313 (19x)
53
EP 5/11/04/12
80
EP 5/11/04/12
B67396 (35x)
B67389 (37x)
EP 5/11/04/12
144

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Shop Packet Print

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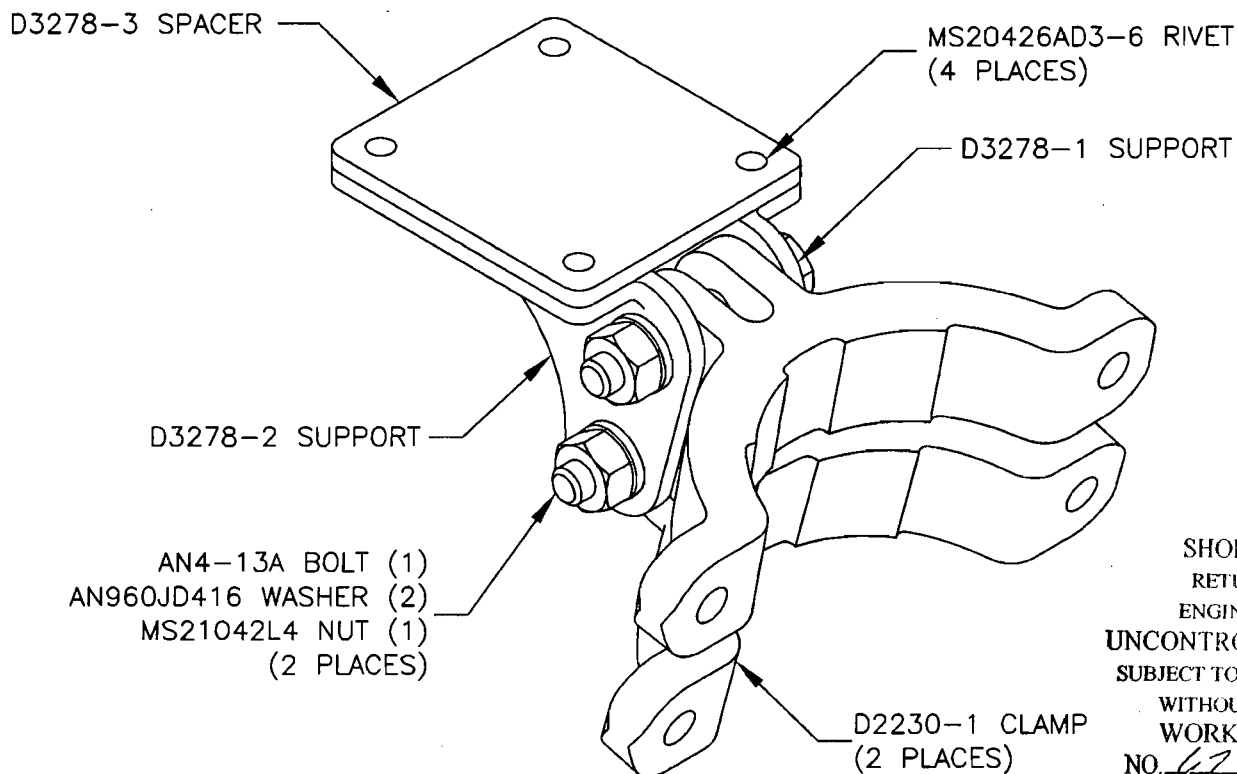
NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62589

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

PL 11-03-25

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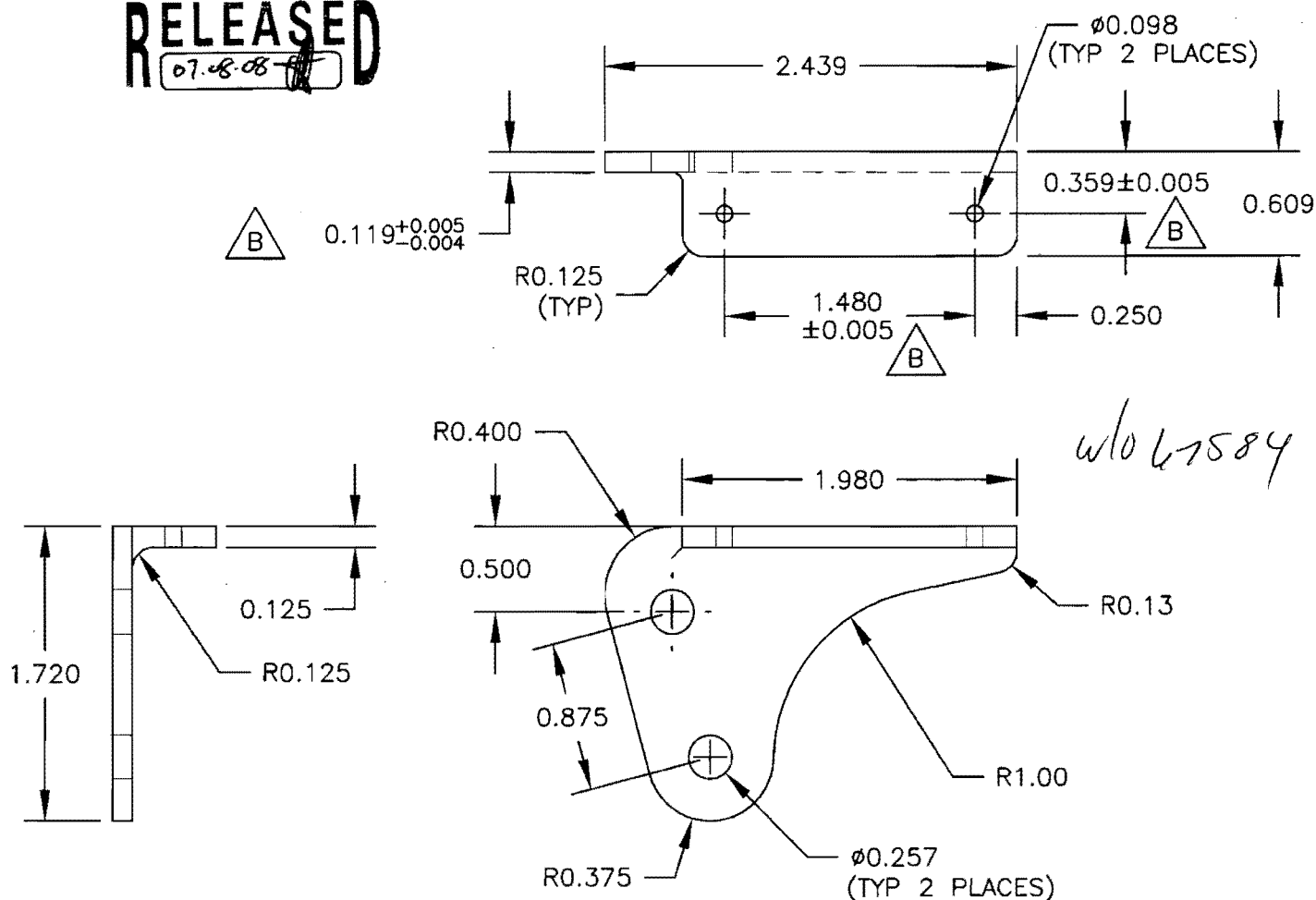
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DESIGN <i>qp</i>	DRAWN BY <i>bc</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>js</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-8-08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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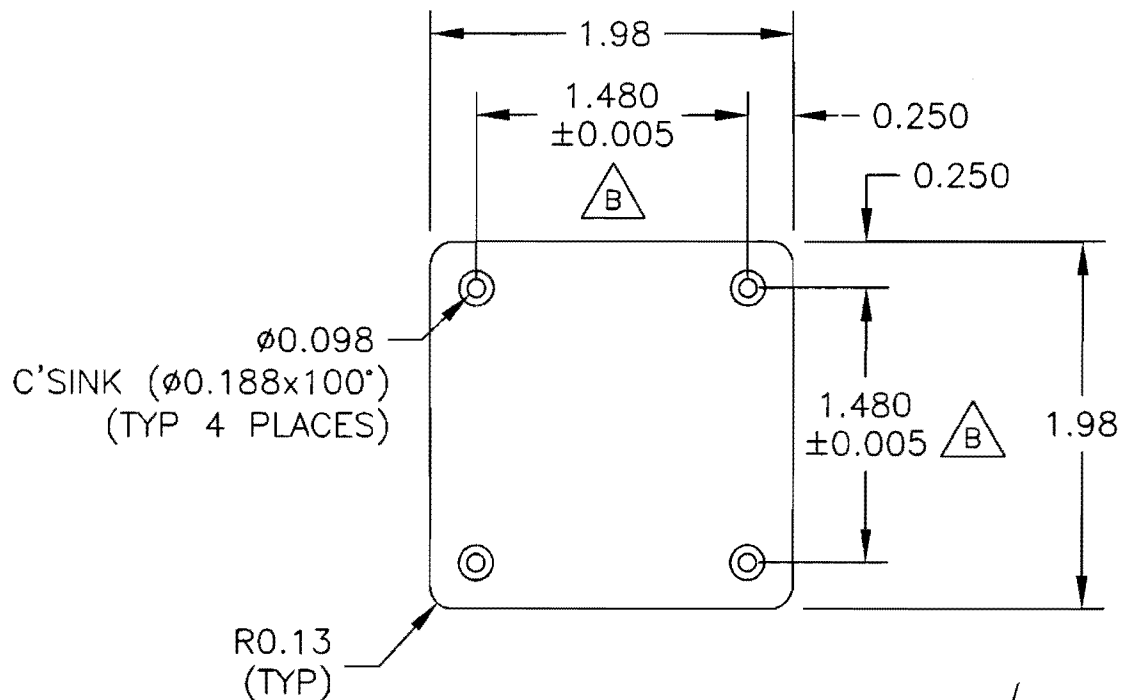
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CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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